

Date: Tuesday, 7/10/2007 1:05:44 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 33450		
Estimate Number	: 10178		
P.O. Number	: <i>N/A</i>	Part Number	: D25941
This Issue	: 7/10/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2594 REV C
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 32651	Drawing Revision	: C
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 7/23/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	500 Um: Each
Comment	: Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0547 f(s)/Unit Total: 27.3525 f(s)
Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)
1100-0 (QQ-A-225/1) Ø0.625" Rod
(M5052H32R0.625) or (M6061T6R0.625) Batch *M10603*

*28.5'**RP 07/11/08**DIP 07/11/07*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
1-Make as per Dwg D2594-1 and Folio FA262.
2-Break all sharp edges 0.010 max.

*DIP 07/11/07**RP 07/11/08*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DIP 07/11/07**RP 07/11/08**(516)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*RP 07/11/08**(516)*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid etch and alodine as per QSI 005 4.1

*RP 07-11-09**(2516)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M-105914



(516)

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

FL 07/11/14

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(516X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/11/14

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(516X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP 8*

M-1 07/11/14

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(516)

Comment: FINAL INSPECTION/W/O RELEASE

LD 07/11/15

Job Completion



W 07-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

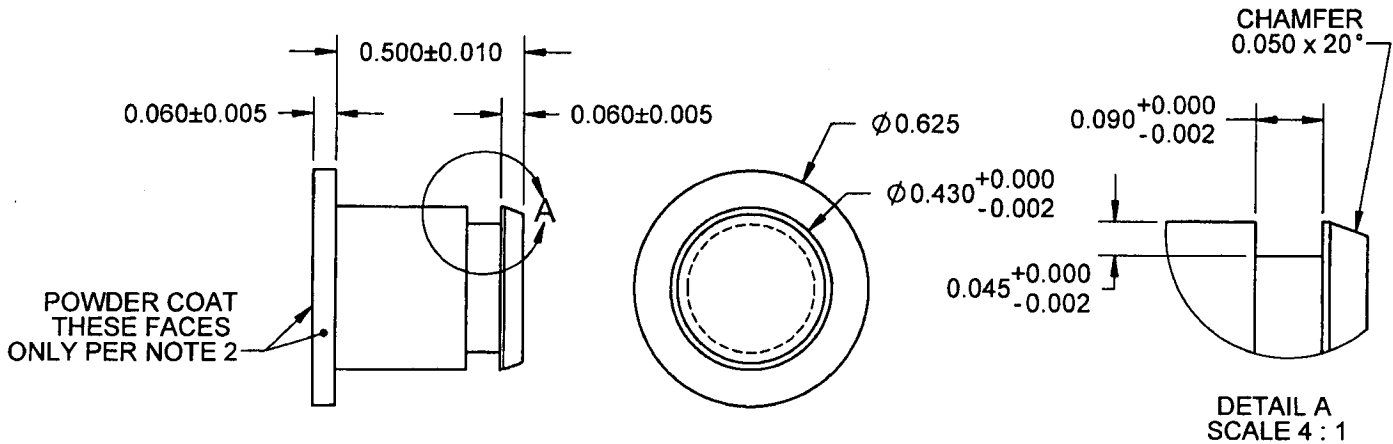
NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG SCALE 2:1		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

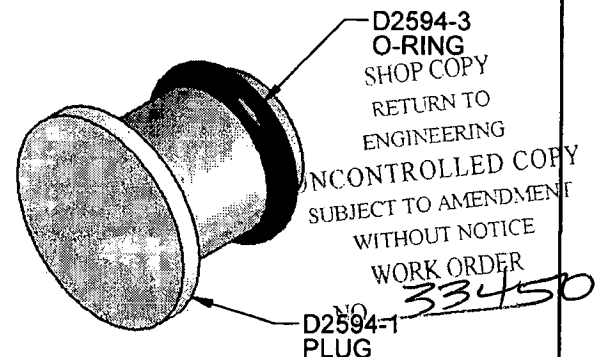
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 $\triangle C$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 $\triangle C$

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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